



Dart Aerospace Ltd.
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DSK078**Job Sheet 191408****Part No:** DSK078**Job Qty:** 10 pcs**Part Name:** D2893-1 Turning Detail**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/28/19**Job Tracking No:****Due Date:** 4/4/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG REV A IPP rev A. 08.03.13 new issue EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	10 pcs	4/4/19	4/4/19	0.50	8.77	Doosan - 1		PMP 2019-03-27
110	QC 2	10 pcs	4/4/19	4/4/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		PMP 2019-03-27
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		



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Container No: S167085**Part:** DSK078**Job No:** 191408**Serial No/Batch:** S167085**Revision:****Inspector:****Exp Date:****Instructions:**

Date: 03/28/19

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120	QC 8	10 pcs	4/4/19	0.00 0.00	QC 2 - 64	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	19-03-28
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
130	Packaging 3-1 - Stock - B4B	10 pcs	4/4/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	

140 QC 21 - SA	10 pcs	4/4/19	0.00 0.00	QC 21 - SA - 21	DAG
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-53
Part Op 100 - Doosan (Doosan Lathe) Turn blank as per Folio FA081 (4TH AXIS PLUG DT8492) Descriptions: 110 - QC2 Machining-4 (QC2- Inspect parts off machine FAI/FAIB) 120 - QC8 Machining-4 (QC8- Inspect parts - second check) 130 - Packaging3-2 (Identify as per dwg & Stock Location: _____) LOCATION: MAT060 140 - QC21 (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6104-005	Round Billet, 17-4	10 pcs (1 ea)	100-Doosan - 1	D6104-005 S124201	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Doosan - 1	D6104-005	10	48	0	
Part Specifications					
Specifications could not be found.					

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DART AEROSPACE LTD		Work Order: 191408
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.709	2.712	2.710	2.710	2.710
B	4.946	4.966		4.955	4.955	4.955	4.955	4.955
C	3.064	3.084		3.074	3.074	3.074	3.074	3.074
D	0.718	0.738		0.727	0.727	0.727	0.727	0.727
E	0.090	0.110		0.101	0.101	0.101	0.101	0.101
F	2.934	2.954		2.9425	2.944	2.944	2.944	2.944
G	2.166	2.186		2.175	2.175	2.175	2.175	2.175
H	3.890	3.910		3.8995	3.900	3.900	3.900	3.900
I	0.914	0.934		0.9245	0.924	0.924	0.924	0.924
J	0.022	0.042		0.0315	0.032	0.032	0.032	0.032
K	0.109	0.129		0.1175	0.1155	0.116	0.117	0.117
L								
M								
N								
O								
P								

Measured by: PMP	DAS 56 9-89	Date: 2019-03-27
Audited by:	DAS 20 9-89	Date: 19-03-28
Prototype Approval:		Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order:	191408
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	#6	#7	#8	#9	#10
Lathe Section								
A	2.707	2.712		2.711	2.709	2.710	2.710	2.710
B	4.946	4.966		4.955	4.955	4.955	4.955	4.955
C	3.064	3.084		3.074	3.074	3.074	3.074	3.074
D	0.718	0.738		0.727	0.727	0.727	0.727	0.727
E	0.090	0.110		0.101	0.101	0.101	0.101	0.101
F	2.934	2.954		2.944	2.944	2.944	2.944	2.944
G	2.166	2.186		2.175	2.175	2.175	2.175	2.175
H	3.890	3.910		3.900	3.900	3.900	3.900	3.900
I	0.914	0.934		0.924	0.924	0.924	0.924	0.924
J	0.022	0.042		0.032	0.032	0.032	0.032	0.032
K	0.109	0.129		0.116	0.118	0.117	0.117	0.117
L								
M								
N								
O								
P								

Measured by:	<i>[Signature]</i>	Date:	19/03/28
Audited by:	DAS 20 8-89	Date:	19-03-28
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					